

Docket No.: BECKER-5
Appl. No.: 09/486,021

**AMENDMENTS TO THE CLAIMS WITH MARKINGS TO SHOW CHANGES
MADE, AND LISTING OF ALL CLAIMS WITH PROPER INDENTIFIERS**

1. (Currently presented) A process for injection molding of injection molded parts from plasticizeable material, comprising the steps of introducing a first plasticized material into a main extruder at a leading area of the main extruder via a secondary extruder; producing a second plasticized material in the main extruder; injecting a the first plasticized material by the main extruder into the hollow of an injection mold through an opening as to wet only a partial area of a wall surface of the hollow, and subsequently injecting a the second plasticized material by the main extruder through the same opening into the hollow as to wet at least a part of the remaining area of the wall surface of the hollow.
2. (Canceled)
3. (Currently presented) The A process for injection molding of injection molded parts from plasticizeable material, comprising the steps of claim 1 wherein the injecting a first plasticized material is injected into the hollow of an injection mold through an opening as to wet only a partial area of a wall surface of the hollow, and subsequently injecting a second plasticized material through the same opening into the hollow as to wet at least a part of the remaining area of the wall surface of the hollow, wherein the first plasticized material is injected into the injection mold to such an extent that

Docket No.: BECKER-5
Appl. No.: 09/486,021

after injection of the other second plasticized material, the first plasticized material extends to a shoulder in the hollow between the partial area and the remaining area, whereby the shoulder is formed by a wall surface of the hollow.

4. (Previously presented) The process of claim 1 wherein after injection of the first material, a slide gate is moved to clear at least a part of the remaining area.
5. (Previously presented) The process of claim 4 wherein the slide gate clears a channel leading to a partial area of the hollow in the injection mold.
6. (Previously presented) The process of claim 4 wherein the slide gate directly clears a partial area of the hollow in the injection mold.
7. (Previously presented) The process of claim 1 wherein during the injection molding steps a gas space is formed in the injection mold.
8. (Previously presented) The process of claim 1 wherein one of the first and second plasticized materials is a relatively soft or rubber-like material, and the other one of the first and second plasticized materials is a relatively hard material.

Docket No.: BECKER-5
Appl. No.: 09/486,021

9. (Previously presented) The process of claim 1 wherein the first and second plasticized materials exhibit at least two different colors or are transparent.
10. (Previously presented) The process of claim 1 wherein at least one of the first and second plasticized materials contains gas pockets.
11. (Previously presented) The process of claim 1 wherein at least one of the first and second plasticized materials contains pockets of another component.
12. (Previously presented) An injection mold, comprising a body member having a wall surface bounding a hollow for so receiving a first plasticized material as to wet only a partial area of the wall surface of the hollow, and subsequently so receiving a second plasticized material as to wet at least a part of the remaining area of the wall surface of the hollow; and a sensor arranged at a transition between the partial area and the remaining area of the wall surface of the hollow of the body member.
13. (Previously presented) The injection mold of claim 12 wherein the body member is formed interiorly with a shoulder arranged at the transition between the partial area and the remaining area of the wall surface of the hollow.

Docket No.: BECKER-5
Appl. No.: 09/486,021

14. (Previously presented) The injection mold of claim 12, and further comprising a hot runner with a by-pass device which enables plasticized material, streaming to the hollow, to flow into an overflow.
15. (Currently presented) An injection molding device, comprising an injection mold; a main extruder with for producing a plasticized material and injecting the plasticized material into a plasticizer unit and an the injection mold unit, said main extruder comprising having a barrel, at least one nozzle with a nozzle tip disposed at a leading end of the barrel adjacent to the injection mold, and a screw received in the barrel for conveying material through the barrel and including a screw tip; and at least two secondary extruders which are fluidly connected to the main extruder and arranged attached to the barrel between the screw tip and the nozzle tip.
16. (Currently presented) An injection molding device having at least one injection unit which includes an injection piston (201) for injecting melt from a melt compartment, and at least two extruders (203, 204) directly connected to this melt compartment.

Docket No.: BECKER-5
Appl. No.: 09/486,021

17. (Currently presented) An injection molding device having a main extruder (237, 257) which includes a melt compartment from which a nozzle extends via a hot runner (241), and a secondary extruder (236, 258), wherein the melt compartment is connected via a control unit (230, 240) to a second channel which is connected with the secondary extruder (236, 258) and leads to the melt compartment, with the control device ~~being coupled with the movement of~~ attached the secondary extruder.
18. (Previously presented) The injection molding device of claim 17, wherein the control unit (230, 240) is rigidly connected with the secondary extruder (236).
19. (Currently presented) The injection molding device of claim 17, wherein the control unit (230) includes an adjustment nozzle which bears upon a surface[, preferably]] of a secondary extruder, and is secured to a flange.
20. (Previously presented) The injection molding device molding device of claim 17, wherein the hot runner (241) includes a pressure-dependent valve (245).

Docket No.: BECKER-5
Appl. No.: 09/486,021

21. (Previously presented) The injection molding device molding device of claim 17, wherein the control unit (230, 240) includes two partial channels (234, 235; 241, 242, 243) which, depending on the position of the control unit, open or close the hot runner or a feed channel from the secondary extruder.
22. (Previously presented) The injection molding device of claim 21, wherein the control unit (230) includes a partial runner block (231) which accommodates the partial channels (234, 235) and is guided in a block guide (233).
23. (Currently presented) An injection molding device comprising a main extruder (257) movable along a path between an injection position and an idle position, and a secondary extruder (258), and a control unit (250) which is arranged between the injection position and the idle position and includes a channel (253) with an inlet (251) and an outlet (252) and which is swingable between a charging position and release position, wherein the inlet (251) ~~points to~~ is aligned with the main extruder (257) in the charging position, and the outlet (252) ~~points to~~ is aligned with the main extruder (257), and wherein the path is cleared for the main extruder (257) in the release position.

Docket No.: BECKER-5
Appl. No.: 09/486,021

24. (Previously presented) The injection molding device of claim 23, wherein the inlet (251) and the outlet (252) define an acute angle relative to one another.
25. (Currently presented) An injection molding device comprising a main extruder movable along a path between an injection position and an idle position, and having a nozzle (301) for projecting in its injection position through a nozzle plate (302) and at least a portion of an adapter plate (303) through an injection opening (304), and a secondary extruder which is shiftable between a charging position and a release position, wherein in the release position the path of the main extruder is cleared and in the charging position an outlet (307) of the secondary extruder ~~points to~~ is aligned with the nozzle (301) of the main extruder, ~~characterized in that~~ wherein the outlet (307) is arranged in an opening (305) of the adapter plate (303) which terminates in the injection opening (304).
26. (Previously presented) The injection molding device of claim 25, wherein the secondary extruder is supported on its side of the outlet, at least in its charging position, by a force applied by the main extruder.

Docket No.: BECKER-5
Appl. No.: 09/486,021

27. (Previously presented) A method of charging a main extruder of an injection molding device with a melt from a secondary extruder, comprising filling the melt into the main extruder via a feed channel in a hot runner which, on the one hand, is connected with the main extruder and, on the other hand, leads to a mold, and so controlling the injection process that in the hot runner between mold and the location at which the feed channel terminates in the hot runner, a sprue of a solidified or solidifying workpiece remains, until the main extruder is filled with melt.
28. (Previously presented) The process of claim 1 wherein the opening is formed in a nozzle of an extruder operatively connected to the injection mold.